

**Work Order ID 65763**

Tuesday, January 25, 2011 8:16:36 AM

Page 1

Item ID: D205-634-041

Accept

Setup Start

Revision ID:

Stop

Item Name: Replacement Skidtube

Start Date: 1/25/2011 Start Qty: 1.00

Cust Item ID:

Required Date: 2/7/2011 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2580

Rev.D DEO-D1

100

0.00



DC

DOCUMENT CONTROL

Memo

0.00

Document Control

Photocopy D205-634 bluefile &amp; type labels per PPP D205-634-041 CHG003

S u 102/16

110

0.00



CNC Bend 1

BENDING MACHINE - SKIDTUBES

Memo

0.00

CNC Delta 100 Bender

1-Bend as per program D2580.C on CNC Bender and Folio 16

2-Cut tubes as per Dwg. D2580

3- scribe batch# in aft end of tube

11-1-27

1365763

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120		0.00							
Skidtubes	Memo	0.00							
Skidtubes	1- Deburr ends and remove bending marks								
	2- Prepare tube for swaging as per QSI 002								
130	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									

B 4/21/31

1 0 BE 1/21/31

W/O:		WORK ORDER CHANGES					
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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140

0.00



Skidtubes

Skidtubes

**Memo**

0.00

1-Weld step D2576 as per Dwg. D2580 and QSI004  
A/R□□□ Aluminum Rod

2-Grind welds on step as per Dwg D2580

3-Insert D4202-1 spacer, swage as per QSI002 and trim/ grind flush per QSI002  
and dwg. Hold x-bolt with DT9701 Use tube expander 1/2 x17G to start  
expansion and finish with 1/2 x 18G to achieve dwg dimension.

4-Drill holes for wearplates using DT 8217 & DT8937 Open holes to 19/64",  
adjust stopper not to hit web. Deburr

6-Drill pilot holes for aft cap using DT 8215 Open holes to 0.208". Deburr

7-Drill pilot holes for Tow ring using DT8091, open to .640" and Deburr

150



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

**Memo**

0.00

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160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

170

Pressure Wash per QSI005 4.3

0.00



HandFinish

Memo

0.00

Hand Finishing

Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch and leave fwd cap out of solution.

1 BR 11-02-7.

180

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME:  
OVEN TEMPERATURE:  
FINISH TIME:

11:15  
825  
11:45

1 BR 11-02-7

W/O:		WORK ORDER CHANGES					
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Run Start

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

190

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

1 0 11/02/10

W/O:		WORK ORDER CHANGES					
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QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

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200

0.00



HandFinish

Hand Finishing

Memo

0.00

1-Install inserts & wearplates & Gaskets as per Dwg. D2580. Use a drop of Sikaflex on insert holes before installing wearplates

A/R ☐ ☐ ☐ Sikaflex-291 ☐ 11151 ☐ ☐

Sikaflex expire date: 11/01

2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2580

3-Inspect for foreign object per QSI 024

4-Install 2855 Aft Cap as per Dwg D2580 and seal Fwd Step & Aft Cap with Sikaflex. Clean excess adhesive

A/R ☐ ☐ ☐ Sikaflex-291 ☐ 11151 ☐ ☐

Sikaflex expire date: 11/01

5-Wing Walk as per Dwg D2580 and QSI 005 4.4

Batch: 1116042

1 0 11/02/11

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QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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210



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024

0.00

Sily



220



Packaging

Packaging

Packaging

0.00

Memo

Identify and pack for shipping as per PPPD205-634-041

Location: \_\_\_\_\_

PPP Rev: \_\_\_\_\_

0.00

11/2/16

230



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

CK 11/02/16

CME

11-02-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Tuesday, January 25, 2011 8:16:44 AM

Page 1

Work Order ID: 65763

Parent Item: D205-634-041

Parent Item Name: Replacement Skidtube



Start Date: 1/25/2011

Required Date: 2/7/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30  
KJ IPP Rev P 10.02.19  
per PAR09-043 EC verified by:DD  
IPP Rev. O 06.02.28 Added paperwork EC  
IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM IPP Rev:Q  
10.12.01 as per chg003 DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4202-1 		Manufactured	No			140	Each	106.0000	20	20			
Spacer													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				LG				106					
					64608			-106					
D2580-1 		Manufactured	No			110	Each	2.0000	1	1			
205 Skidtube bent detail													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				LG				1					
					63051			1					
				ST046				1					
					59856			1					
D2576-3 		Manufactured	No			140	Each	62.0000	1	1			
Step (maching detail)													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				LG				62					
					46661			14					
					52215			48					

BE 11/02/02

20

DD 11-1-27

BE 11/01/31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Page 2

Work Order ID: 65763

Parent Item: D205-634-041

Parent Item Name: Replacement Skidtube



Start Date: 1/25/2011

Required Date: 2/7/2011

Start Qty: 1.00

Required Qty: 1.00

D2855

Manufactured No

200

Each

54.0000

1

1



Cap



11/02/10

## Location

## Loc Qty

## Loc Code

FP6

3

56613

1

63634

2

ST026

51

50513

1

50770

28

51539

2

53791

20

11

AN3-5A

Purchased

No

200

Each

1,079.000

2

2



Bolt



11/02/10

## Location

## Loc Qty

## Loc Code

ST350

1079

115016

379

115371

500

116632

200

x2

AN960JD10L

NAS1149D0332J

Purchased

No

200

Each

0.0000

2

2



Washer

11/02/10



(x2) 11/02/10

Tuesday, January 25, 2011 8:16:44 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
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Start Date: 1/25/2011

Required Date: 2/7/2011

Start Qty: 1.00

Required Qty: 1.00

ALS7-1032-130 Purchased

No

200

Each

1,628.000

50

50



Insert



11/02/10

## Location

## Loc Qty

## Loc Code

FP

689

115079

689

ST282

939

113238

17

115502

500

115581

422

M114723

x50

AN3C4A

Purchased

No

200

Each

1,172.000

50

50



BOLT



11/02/10

## Location

## Loc Qty

## Loc Code

ST350

1172

115300

25

116075

947

116590

200

x50

AN960C10L

NAS1149C0332

Purchased

No

200

Each

25.0000

50

50



washer



11/02/10

## Location

## Loc Qty

## Loc Code

ST245

25

107534

25

M116025

x50

Tuesday, January 25, 2011 8:16:45 AM

Shop Packet Print

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Required Date: 2/7/2011

Start Qty: 1.00



Required Qty: 1.00

D3566-13      Manufactured      No      200      Each      25.0000      1      1  
  42 11/02/10  
 Gasket



Location	Loc Qty	Loc Code
FP012	5	
<u>61996</u>	5	<u>X1</u>
FP014	20	
64070	20	

D3566-5      Manufactured      No      200      Each      10.0000      1      1  
  42 11/02/10  
 Gasket

Location	Loc Qty	Loc Code
FP	9	
64789	9	
FP015	1	
63574	1	<u>B66146</u>

D3566-1      Manufactured      No      200      Each      4.0000      2      2  
  42 11/02/10  
 Gasket

Location	Loc Qty	Loc Code
FP015	4	
57715	1	<u>1365988</u>
63573	3	<u>V2</u>

D3564-11      Manufactured      No      200      Each      7.0000      1      1  
  42 11/02/10  
 Wearshoe

Location	Loc Qty	Loc Code
FP019	7	
<u>62236</u>	7	<u>X1</u>

W/O:		WORK ORDER CHANGES					
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Start Date: 1/25/2011



Required Date: 2/7/2011

Start Qty: 1.00



Required Qty: 1.00

D3564-13      Manufactured      No      200      Each      15.0000      1      1  
  HL 11/02/10  
Wearshoe

Location	Loc Qty	Loc Code
FP17	15	
59660	1	
61828	2	
<u>62229</u>	12	

D3564-9      Manufactured      No      200      Each      16.0000      1      1  
  HL 11/02/10  
Wearshoe

Location	Loc Qty	Loc Code
FP	1	
55334	1	
FP19	15	
<u>62238</u>	15	

D3564-5      Manufactured      No      200      Each      20.0000      1      1  
  HL 11/02/10  
Wearshoe

Location	Loc Qty	Loc Code
FG	1	
34806	1	
FP19	2	
57525	1	
58709	1	
FP-19	17	
63575	6	
<u>65058</u>	11	

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Start Date: 1/25/2011

Required Date: 2/7/2011

Start Qty: 1.00

Required Qty: 1.00

D2594-3

Manufactured No

200

Each

739.0000

16

16



O-Ring, 205 Skidtube



XL 11/02/10

Location

Loc Qty

Loc Code

FP

43

55546

19

58191

12

59358

12

fpa

696

61762

696

XL6

D2594-1

Manufactured No

200

Each

235.0000

16

16



Plug, 205 Skidtube



XL 11/02/10

Location

Loc Qty

Loc Code

FP

183

42807

112

55002

71

FP14

52

58434

15

62893

37

B65980

XL6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**DART****RELEASED**  
07-06-28**DEO ATTACHED**

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2580	REV. D SHEET 1 OF 3
DATE 07.02.27		TITLE 205 SKIDTUBE ASSEMBLY	SCALE NTS
A	96.09.16	NEW ISSUE	
B	96.12.02	AS MANUFACTURED	
C	98.08.26	REDRAWN, INCLUDED DEO 9094/9097	
D	07.02.27	CHANGE TO SS WEARPLATES AND GASKETS, INCLUDE DEO 9124/9183	

QTY -041	QTY -045	Part Number	Description
X		D2580-041	SKIDTUBE ASSEMBLY
	X	D2580-045	SKIDTUBE ASSEMBLY
1	1	D2500-1-190	EXTRUSION
1	1	D2576-3	STEP
20	24	D2579	CROSS BOLT SPACER
16	16	D2594-1	PLUG
16	16	D2594-3	O-RING
1	1	D2596	205 WEB
1	1	D2855	AFT CAP
1	1	D3564-5	WEARSHOE
1	1	D3564-9	WEARSHOE
1	1	D3564-11	WEARSHOE
1	1	D3564-13	WEARSHOE
2	2	D3566-1	GASKET
1	1	D3566-5	GASKET
1	1	D3566-13	GASKET
50	50	ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or AELS-1032-130	INSERT
50	50	AN3C4A	BOLT
2	2	AN3-5A	BOLT
50	50	AN960C10L	WASHER
2	2	AN960JD10L	WASHER

**GENERAL NOTES:**

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 5) USE DART DRILL TEMPLATE TD2577-205 TO LOCATE AND DRILL Ø.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION D-D (50 PLACES) AFTER FINISH. INSTALL AN3C4A BOLTS AND AN960C10L WASHERS WITH SIKAFLEX-241/-291.
- 6) WELDING TO BE DONE PER DART QSI 004.
- 7) FINISH:  
SEE NOTES ON  
PAGE 2 FOR D2580-041 AND  
PAGE 3 FOR D2580-045
- 8) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES).

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 45763

BS 11-01-25

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

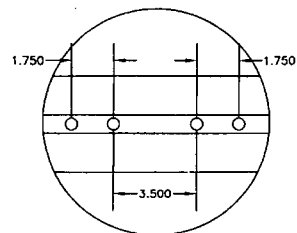
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

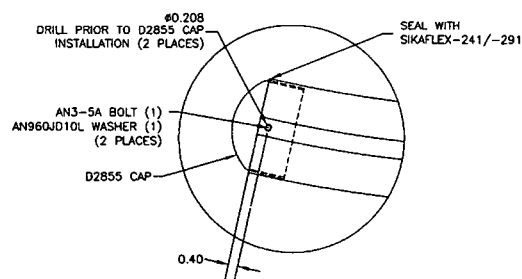
**DETAIL A**  
SCALE 5:24



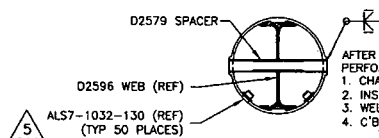
RELEASED  
07-06-28

DEO ATTACHED

**DETAIL C**  
SCALE 5:24



**SECTION D-D**  
SCALE 5:24



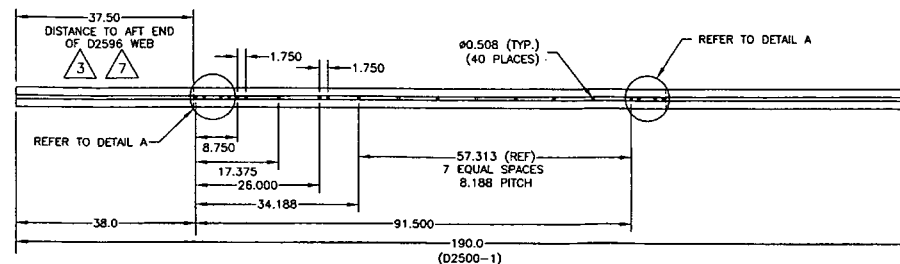
AFTER DRILLING AND BENDING ASSEMBLY  
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:

1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2579 SPACER (20 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. C'BORE D2579 SPACER TO Ø0.437 X 1.00 DEEP

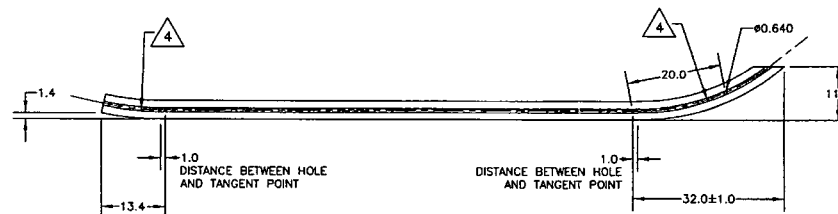
## D2580-041 NOTES

- i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB POWDER COAT ASSEMBLY GLOSS WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3 BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4

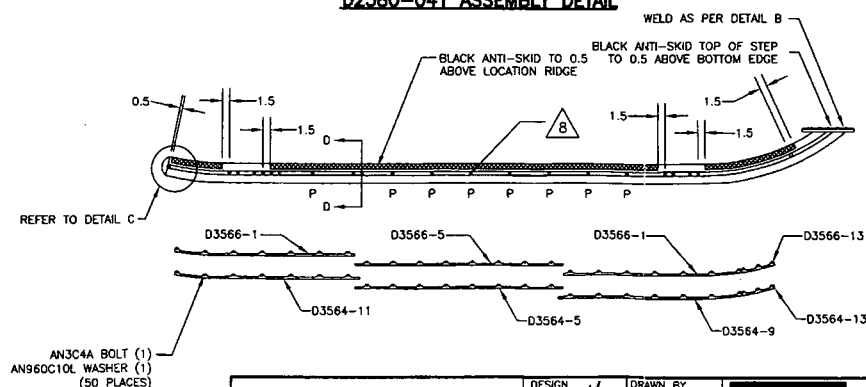
D2580-1 DRILLING DETAIL



D2580-1 BENDING AND CUTTING DETAIL



D2580-041 ASSEMBLY DETAIL



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CHECKED

APPROVED

DATE \_\_\_\_\_

07.02.27

**DART**

**DART AEROSPACE LTD.**  
HAMMERSLEY, ONTARIO, CANADA

	DRAWING NO
--	------------

D2580

	DATE	TIME	LOCATION	REMARKS
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72	10/10/2018	10:00	100m	100m
73	10/10/201			

205 SKIDTUBE ASSEMBLY

REV. 0

SHEET 2 OF 3

SCA 1

1:24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

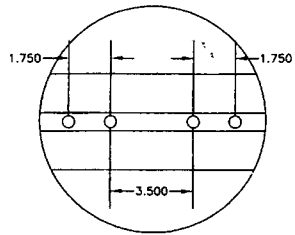
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

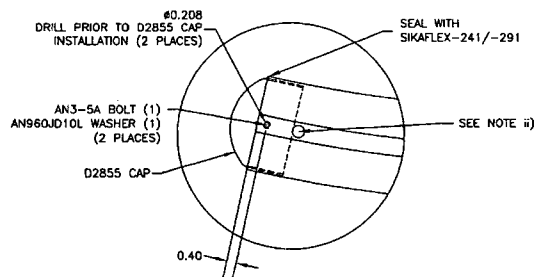
**DETAIL E**  
SCALE 5:24



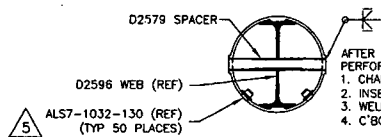
RELEASED  
07-06-28

DEO ATTACHED

**DETAIL G**  
SCALE 5:24



**SECTION H-H**  
SCALE 5:24



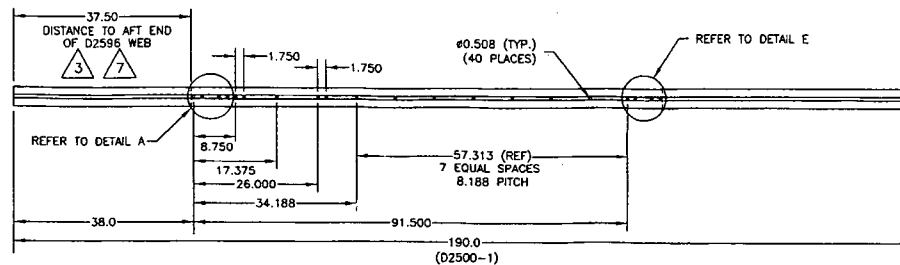
AFTER DRILLING AND BENDING ASSEMBLY  
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:

1. CHAMFER HOLE 0.050 X 45°
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4. C'BORE D2579 SPACER TO Ø0.437 X 1.00 DEEP

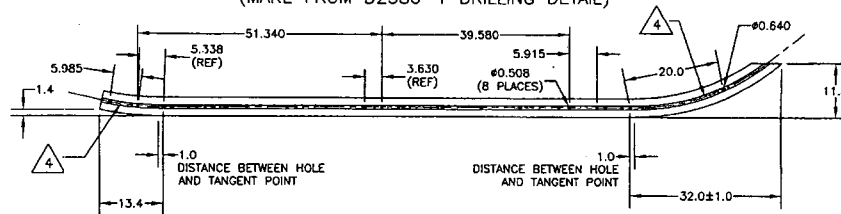
**D2580-045 NOTES**

- i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB  
POWDER COAT ENTIRE ASSEMBLY GREEN (REF. 4.3.5.8) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4
- ii) IT IS ACCEPTABLE TO GRIND A RELIEF IN THE D2855 AFT CAP TO PREVENT INTERFERENCE  
WITH THE SPACER AT THIS LOCATION

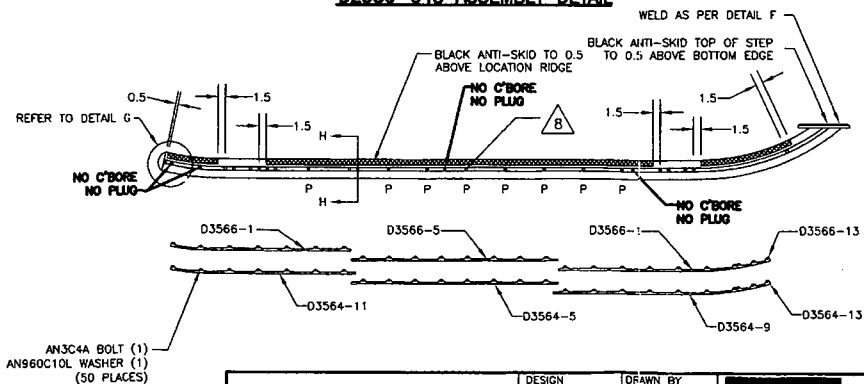
D2580-1 DRILLING DETAIL



**D2580-5 BENDING AND CUTTING DETAIL**  
(MAKE FROM D2580-1 DRILLING DETAIL)



D2580-045 ASSEMBLY DETAIL



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DESIGN

CHECK	
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DATE \_\_\_\_\_

07.02.27

**DRAWN BY**

APPROVED

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**DART**

**DART AEROSPACE LTD.**  
HAMPSHIRE, ONTARIO, CANADA

REV. D

SHEET 3 OF 3

[illegible]

205 SKIDTUBE ASSEMBLY

SCALE

1:24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 65763**

Tuesday, January 25, 2011 8:16:36 AM

Accept

Setup Start

Stop

Item ID: D205-634-041

Revision ID:

Item Name: Replacement Skidtube

Start Date: 1/25/2011 Start Qty: 1.00

Required Date: 2/7/2011 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Run Start

Stop

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D2580

Rev.D DEO-D1

0.00

100

DOCUMENT CONTROL

0.00

DC

Document Control

Memo

Photocopy D205-634 bluefile &amp; type labels per PPP D205-634-041 CHG003

0.00

110

BENDING MACHINE - SKIDTUBES

0.00

CNC Bend I

CNC Delta 100 Bender

Memo

1-Bend as per program D2580.C on CNC Bender and Folio 16

2-Cut tubes as per Dwg. D2580

3- scribe batch# in aft end of tube

C211102116

11-1-27